

5892



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SMALL FAB

RBW6505G00831-3G

Job Sheet 177854

SHIP
7-02NO
FAL

Part No: RBW6505G00831-3G

Job Qty: 1 ea

Part Name: Tail Rotor Gear Box Support Trolley Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/18/18

Job Tracking No:

Due Date: 6/25/18

Created By: Logan David

Type: SOLD

Description:

Note: URF17-785 DWG RBW6505G00831-3G Rev2 IPP Rev A 17.11.21 New issue DP Verify DD

Ship Via: OKAY TO SHIP MGA 07/03/18

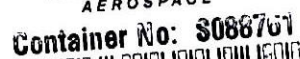
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/25/18	6/25/18	0.00	0.00	Start Up Small Fab-4		MU DAS
110	Small Fab	1 pcs	6/25/18	6/25/18	0.00	1.00	Small Fab-8		MU 38
120	QC	1 pcs	6/25/18	6/25/18	0.00	0.00	QC5		SD 9-89
130	Packaging	1 pcs	6/25/18	6/25/18	0.00	0.00	Packaging3-1		DAS 21
140	QC21-FG	1 Ea	6/25/18	6/25/18	0.00	0.00	QC21		21 JUL 03 2018

Part Op 90 - DWG needs engineering sign off for Ferrule 3896131 and cable CL-2-C
Descriptions: 110 - Assemble as per DWG. Sheet 1 & 2

9-89



Job No: 177854

Revision: 2

Revision: _____
Inspector: _____

Inspector:
Exp Date:

Exp Date:
Instructions:

Date: 07/03/18

177854

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	6 Ea (6 ea)	90-Start up	
			Operation	
3896T31	Ferule 1/16 X 3/8" - Aluminum	6 Ea (6 ea)	90-Start up	
			Operation	5054248
90177A219 63	Split Ring	6 Ea (6 ea)	90-Start up	
			Operation	5015388
90949A016 66	Locknut	2 Ea (2 ea)	90-Start up	
			Operation	5015389
91251A421 68	Socket Head Cap Screw	2 Ea (2 ea)	90-Start up	
			Operation	5037411
91251A426 68	Socket Head Cap Screw	2 Ea (2 ea)	90-Start up	
			Operation	5015390
91259A583 70	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	2 Ea (2 ea)	90-Start up	
			Operation	5015387
91654A076 52	#2 Drive Screw	4 Ea (4 ea)	90-Start up	
			Operation	5015391
92620A540 55	Hex Head Cap Screw	4 Ea (4 ea)	90-Start up	
			Operation	5084062
94744A240 57	Flat Washer	4 Ea (4 ea)	90-Start up	
			Operation	5015393
95395A226 38	Washer	2 Ea (2 ea)	90-Start up	
			Operation	5070278
98099A031 04	Washer	2 Ea (2 ea)	90-Start up	
			Operation	5015395
CL-2-C	Lanyard Wire	1.5000 ft (1.5 ea)	90-Start up	
			Operation	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up	
			Operation	5021690
RBW6505G00831-3G-1	Leg Assembly Weldment	1 Ea (1 ea)	90-Start up	
			Operation	5084048
RBW6505G00831-3G-19 Swivel Base	— B2A	1 Ea (1 ea)	90-Start up	
			Operation	501796602
RBW6505G00831-3G-21 Swivel Plate	— 98	1 Ea (1 ea)	90-Start up	
			Operation	5080558
RBW6505G00831-3G-23 Bar	98	1 Ea (1 ea)	90-Start up	
			Operation	5080855
RBW6505G00831-3G-25 Mount Plate	98	1 Ea (1 ea)	90-Start up	
			Operation	5080869
RBW6505G00831-3G-41 Pin	98	3 Ea (3 ea)	90-Start up	
			Operation	5050995
RBW6505G00831-3G-7 Swivel Plate Weldment	—	1 Ea (1 ea)	90-Start up	
			Operation	5084009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	12	486	0
	90177A219	6	44	0
	90949A016	2	98	0
	91251A421	2	18	0
	91251A426	2	23	0
	91259A583	2	12	0
	91654A076	4	95	0
	92620A540	4	96	0
	94744A240	4	21	0
	95395A226	2	13	0
	98099A031	2	8	0
	CL-2-C	2	314	0
	RB41011	1	884	0
	RBW6505G00831-3G-1	1	0	0
	RBW6505G00831-3G-19	1	0	0
	RBW6505G00831-3G-21	1	6	0
	RBW6505G00831-3G-23	1	6	0
	RBW6505G00831-3G-25	1	8	0
	RBW6505G00831-3G-41	3	13	0
	RBW6505G00831-3G-7	1	0	0

@11094
→ @120411.6

-3
-5

L.FAB 17859

To us 178020

M.H. 118322

6.013

L.FAB 17804

178040 - 52350

178021 e.d.

178023 - 3 @ AKG

GA 055 T2FAB2

not started

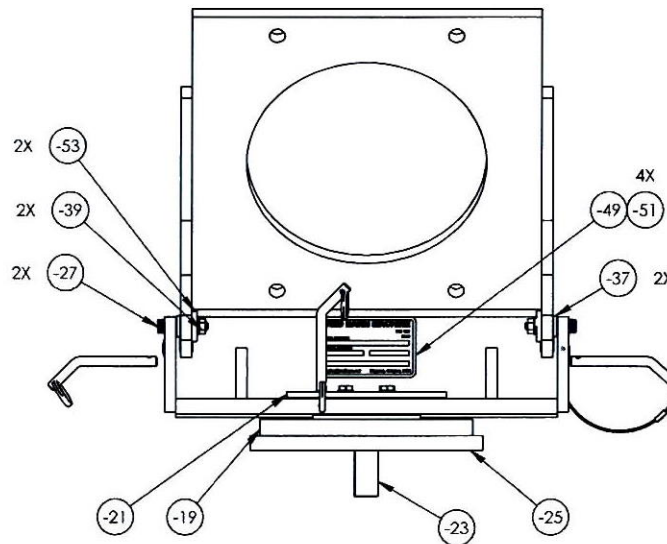
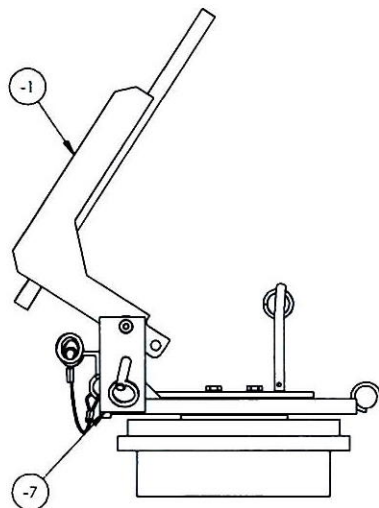
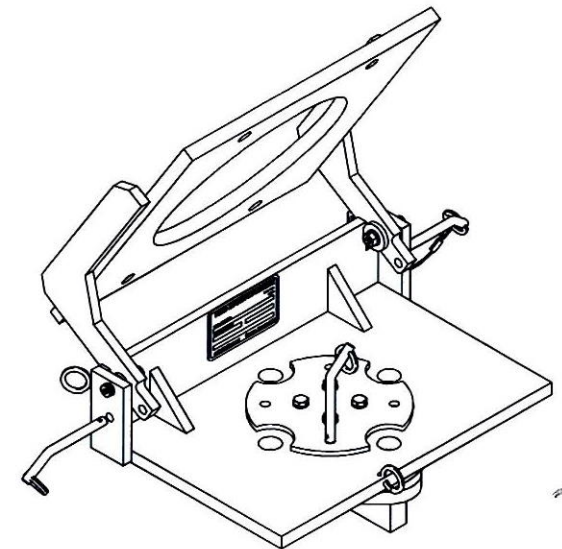
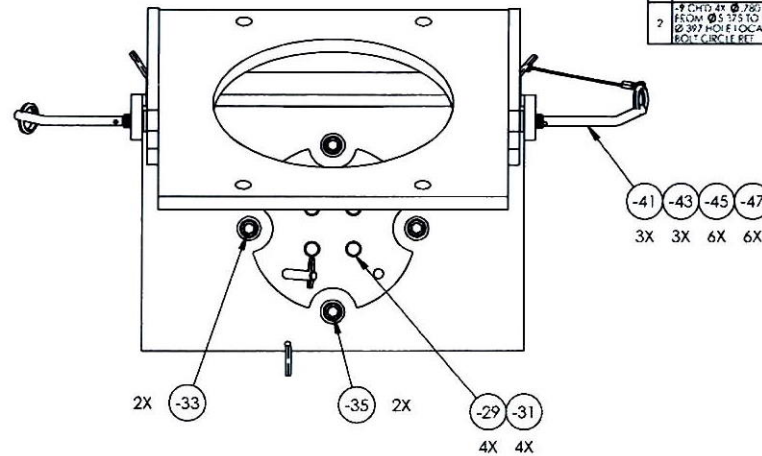
Part Specifications	
Specifications could not be found.	

Plex 6/20/18 1:40 PM dart.logan.david

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED SHEET 16 FOR 41. SHEET 5 CHD .5 DIMENSION LOCATION WAS 6.255 IS 7.255	5/10/2013	CFS	
2	8 CHD 4X .789 HOLE R.C. FROM .05.375 TO .05.512 -19 CHD COUNTER BORED HOLES R.C. FROM .05.175 TO .05.512 -23 CHD HOLE LOCATIONS FROM 5.38 TO 5.51 -25 CHD 3/8-24 AND .05.397 HOLE LOCATIONS FROM 2X 1.90 AND 2X 3.89 TO 7.1.25 AND 2X 3.80 AND ADDED .05.512 BOLT CIRCLE R.T.	7/12/2013	RJC	RW

TEO ATTACHED

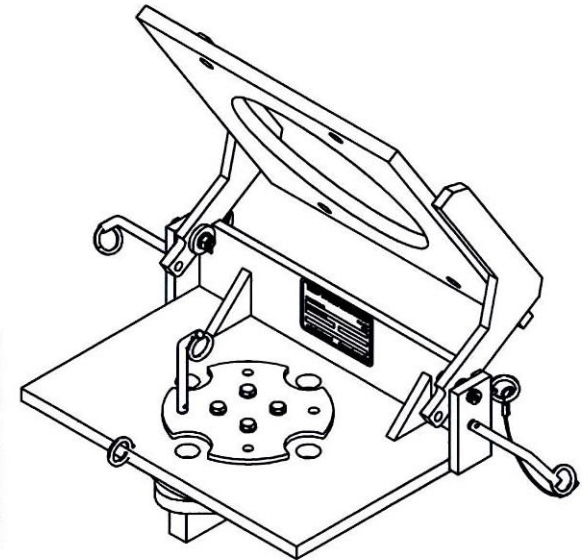


RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G	REV 2
DRAWN BY: CLOUGH	APPROVED: D. Wood
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	REMARKS:
XXX ± .005 FRACTIONS ± 1/32	REAT
XX ± .01 ANGLES ± .5°	REAT
X ± .1	REAT
1. BREAK ALL SHARP EDGES .015 x 45°	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:4	DATE 2/6/2012
SHEET 1 OF 16	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
			APPROVED

TEO ATTACHED



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	LEG ASSY. WELDMENT			3
	1		-3		PLATE	A36 P&O	1/2 X 11-5/8 X 11-5/8	4
	2		-5		LEG	A36 P&O	1/2 X 6 X 7-3/8	5
X			-7	1	SWIVEL PLATE WELDMENT			6
1			-9		PLATE	A36 P&O	1/2 X 8-1/8 X 12-11/16	7
1			-11		BACK PLATE	A36 P&O	3/8 X 3-1/8 X 12-5/8	8
2			-13		END	A36 P&O	3/8 X 1-1/2 X 3-5/16	9
2			-15		GUSSET	A36 P&O	3/8 X 1-3/16 X 1-3/16	10
1			-17		SHELF	1018	1/8 X 3/4 LEG X 12-7/16	11
			-19	1	SWIVEL BASE	1018	Ø7 X 1-3/8	12
			-21	1	SWIVEL PLATE	A36 P&O	3/16 X 5-1/2 X 5-1/2	13
			-23	1	BAR	6061	3/4 X 1-1/2 X 6-5/8	14
			-25	1	MOUNT PLATE	6061	1/2 X 6-1/8 6-1/8	15
		B/O	-27	2	SHOULDER SCREW	STEEL	Ø5/16 X 1 SHOULDER, 1/4-20 MCMASTER-CARR #91259A583	1
		B/O	-29	4	HEX HEAD CAP SCREW	STEEL	1/4-20 UNC X 3/4 MCMASTER-CARR #92620A540	1
		B/O	-31	4	FLAT WASHER	STEEL	Ø9/32 I.D. X 1/2 O.D. MCMASTER-CARR #94744A240	1
		B/O	-33	2	SOCKET HEAD CAP SCREW	STEEL	3/8-24 UNF X 5/8 MCMASTER-CARR #91251A421	1
		B/O	-35	2	SOCKET HEAD CAP SCREW	STEEL	3/8-24 UNF X 1-1/4 MCMASTER-CARR #91251A426	1
		B/O	-37	2	WASHER	BRASS	Ø11/32 I.D. X 11/16 O.D. X .11 - .14 MCMASTER-CARR #953925A226	1
		B/O	-39	2	LOCKNUT	STEEL	1/4-20 UNC MCMASTER-CARR #90949A016	1
			-41	3	PIN	STEEL	Ø5/16 X 2-1/2 USABLE MCMASTER-CARR #90146A059 (MODIFIED)	16
		B/O	-43	3	LANYARD	COATED GALV. STEEL	(7X7 CABLE) Ø1/16 X 6 CARR LANE #CL-2	1
		B/O	-45	6	OVAL SLEEVE	ALUMINUM	Ø1/16 X 3/8 MCMASTER-CARR #3896T31	1
		B/O	-47	6	SPLIT RING	STEEL	Ø1.10 O.D. MCMASTER-CARR #90177A219	1
		B/O	-49	1	RED BARN PLACARD	ALUMINUM	R841009	1
		B/O	-51	4	#2 DRIVE SCREW	STEEL		N/S
		B/O	-53	2	WASHER	STEEL	Ø13/32 I.D. X 1 O.D. X .17-.2 MCMASTER-CARR #98099A031	1
ASSY #7	ASSY #1							

 RED BARN MACHINE		TITLE	
		TROLLEY ADAPTER, TGB SUPPORT	
DWG NO.		REV	
RBW6505G00831-3G		2	
MAT'L		DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL AW139	
SCALE	1:6	DATE	2/6/2012
		SHEET 2 OF 16	